Work Order ID 119473

Friday, May 16, 2014 12:44:07 PM

119473

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle

Start Date: 5/15/14 **Start Qty:** 40.00 *40*

Required Date: 5/15/14 **Req'd Qty:** 40.00 *40*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-05-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3500	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAAS CNC VERTICAL MACHINING #1	0.00				40	ϕ		DAS 44 9-89 14/10/12 JFC 2014-10-14
100									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No. 119473 Double check by: ___ 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA641 and inspect p								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				40	ϕ		DAS 44 9-89 14/10/12 JFC 2014-10-14
110									
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				40	o		DAS 14 9-89
120									
QC	**Memo**	0.00							
Quality Control									

ark 14/10/22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Work Order ID 119473

Friday, May 16, 2014 12:44:07 PM

119473

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle

Start Date: 5/15/14 **Start Qty:** 40.00 *40* **Cust Item ID:**

Required Date: 5/15/14 **Req'd Qty:** 40.00 *40* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				40	0	14-10-24	
130									
HandFinish	**Memo**	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				40	0	14-10-27	
140	121808								
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:00 OVEN TEMPERATURE: 1,200. FINISH TIME: 222								
150	QC3- Inspect Part Finish	0.00				40		14-10-28	
150									
QC	**Memo**	0.00							
Quality Control									

DAS 34 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
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☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Item ID: D3500-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle
Start Date: 5/15/14 **Start Qty:** 40.00 *40*
Required Date: 5/15/14 **Req'd Qty:** 40.00 *40*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 5406	0.00				40			4/11/14 DAS 36 9-89
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							4/11/14
170									
QC	**Memo**	0.00							
Quality Control									

4-11-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

Friday, May 16, 2014 12:44:11 PM

Work Order ID: 119473 *119473*

Parent Item: D3500-1 *D3500-1*

Parent Item Name: Saddle

Start Date: 5/15/14 **Required Date:** 5/15/14

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	154.0000	1	40			

D6102-013

Saddle Billet

Location	Loc Qty	Loc Code		
MAT040	52			
104299	22			
105041	20			
105554	10			
MAT041	60			
117029	60			
MAT046	42			
109518	10			
110225	12			
110994	8			
111533	12			
121556			40	

DAS 44 9-89 14/10/12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
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☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	119473
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.376	.377	0.376		
F	0.490	0.510		.499	.498	.498	0.496		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.5885	1.589	1.5845		
J	0.240	0.260		.247	.248	.247	0.247		
K	0.490	0.510		.499	.500	.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.508	6.508	6.508	6.507		
P	5.990	6.010		6.000	5.998	5.999	5.998		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.549	.549	0.543		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.1335	1.134	1.138	1.1325		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	0.630		
AD	0.240	0.260		.256	.256	.255	0.255		
AE	1.810	1.830		1.820	1.822	1.822	1.820		
AF	0.240	0.260		.250	.251	.251	0.250		
AG	0.140	0.160		.150	.151	.150	0.150		
AH	0.140	0.160		.152	.153	.153	0.155		
AI	0.140	0.160		.153	.155	.155	0.158		
Accept/Reject				✓	✓	✓	✓		

Measured by:	FK / JH
Date:	14/10/12 / 2014-10-14

Audited by	DAS 14
Date:	9-89 14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	119473
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.376	0.375	0.376		
F	0.490	0.510		0.498	0.496	0.496	0.497		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5864	1.5857	1.587	1.5875		
J	0.240	0.260		0.247	0.248	0.248	0.248		
K	0.490	0.510		0.499	0.498	0.497	0.503		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.509	6.508	6.508	6.509		
P	5.990	6.010		5.997	6.006	6.006	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.543	0.552	0.5525	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1344	1.134	1.1355	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.252	0.250	0.251	0.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.250	0.251	0.251	0.251		
AG	0.140	0.160		0.150	0.150	0.151	0.153		
AH	0.140	0.160		0.155	0.156	0.156	0.157		
AI	0.140	0.160		0.158	0.150	0.150	0.150		
Accept/Reject									

Measured by:	JFL
Date:	2014-10-14

Audited by	DAS 14
Date:	9-89 14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	119473
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.378	0.375	0.379	0.377		
F	0.490	0.510		0.498	0.498	0.498	0.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5865	1.5864	1.5869	1.5867		
J	0.240	0.260		0.248	0.248	0.250	0.250		
K	0.490	0.510		0.498	0.498	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.508	6.508	6.506		
P	5.990	6.010		6.006	6.004	6.007	6.008		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1347	1.135	1.1349	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.820	1.821	1.820	1.820		
AF	0.240	0.260		0.253	0.250	0.252	0.251		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.157	0.153	0.154	0.154		
AI	0.140	0.160		0.152	0.150	0.153	0.153		
Accept/Reject									

Measured by:	JH
Date:	2014-10-14

DAS

Audited by	14
Date:	9-89 4/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	119473
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.376	0.378	0.378	0.378		
F	0.490	0.510		0.498	0.498	0.497	0.497		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5865	1.5875	1.5851	1.587°		
J	0.240	0.260		0.247	0.248	0.248	0.248		
K	0.490	0.510		0.499	0.499	0.498	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.507	6.507	6.507		
P	5.990	6.010		6.006	6.006	6.006	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.553	0.553	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1343	1.135	1.1335	1.134		
AB	R.490	R.510		0.500	0.502	0.500	0.502		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.250	0.251	0.253	0.253		
AE	1.810	1.830		1.820	1.820	1.819	1.820		
AF	0.240	0.260		0.251	0.251	0.250	0.252		
AG	0.140	0.160		0.151	0.150	0.150	0.151		
AH	0.140	0.160		0.155	0.155	0.155	0.155		
AI	0.140	0.160		0.150	0.152	0.153	0.152		
Accept/Reject									

Measured by:	DFC
Date:	2014-10-15

Audited by	DAS 14
Date:	~~2014~~/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	119473
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.378	0.377	0.377		
F	0.490	0.510		0.498	0.498	0.499	0.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5864	1.587	1.588	1.5879		
J	0.240	0.260		0.247	0.247	0.247	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.506	6.506	6.506		
P	5.990	6.010		6.007	6.007	6.007	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.134	1.135	1.1353	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.253	0.253	0.254	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.251	0.253	0.251		
AG	0.140	0.160		0.150	0.150	0.151	0.151		
AH	0.140	0.160		0.154	0.154	0.155	0.155		
AI	0.140	0.160		0.153	0.154	0.153	0.153		
Accept/Reject									

Measured by:	JFC
Date:	2014-10-15

Audited by	DAS 14
Date:	2014/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	119473
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.378	0.378	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.587	1.5879	1.5868		
J	0.240	0.260		0.246	0.246	0.247	0.247		
K	0.490	0.510		0.501	0.501	0.501	0.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.506	6.507	6.507	6.507		
P	5.990	6.010		6.004	6.005	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1354	1.135	1.1355	1.1343		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.255	0.255	0.253	0.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.252	0.252	0.251	0.252		
AG	0.140	0.160		0.151	0.151	0.151	0.150		
AH	0.140	0.160		0.155	0.153	0.155	0.155		
AI	0.140	0.160		0.154	0.154	0.153	0.153		
Accept/Reject									

Measured by:	JFL
Date:	2014-10-15

Audited by	DAS 14
Date:	9-89 4/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	119473
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.378	0.378		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5868	1.5877	1.5895	1.5864		
J	0.240	0.260		0.247	0.247	0.245	0.245		
K	0.490	0.510		0.501	0.501	0.500	0.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.507	6.507	6.507		
P	5.990	6.010		6.006	6.0016	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.547	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1344	1.1347	1.1352	1.1344		
AB	R.490	R.510		0.500	0.300	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.253	0.253	0.253	0.253		
AE	1.810	1.830		1.820	1.820	1.819	1.820		
AF	0.240	0.260		0.252	0.252	0.252	0.252		
AG	0.140	0.160		0.150	0.151	0.150	0.150		
AH	0.140	0.160		0.155	0.155	0.153	0.153		
AI	0.140	0.160		0.154	0.153	0.153	0.155		
Accept/Reject									

Measured by:	JFC
Date:	2014-10-15

DAS

Audited by	14
Date:	9-89 14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	119473
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	29	30	31	32	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.378	0.376	0.376		
F	0.490	0.510		0.499	0.499	0.498	0.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5863	1.5875	1.5874	1.5875		
J	0.240	0.260		0.245	0.247	0.248	0.248		
K	0.490	0.510		0.501	0.501	0.501	0.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.506	6.505	6.506		
P	5.990	6.010		6.005	6.006	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1334	1.1352	1.135	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.253	0.254	0.247	0.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.252	0.250	0.250		
AG	0.140	0.160		0.150	0.151	0.150	0.150		
AH	0.140	0.160		0.154	0.154	0.155	0.155		
AI	0.140	0.160		0.154	0.154	0.152	0.154		
Accept/Reject									

Measured by:	JFL
Date:	2014-10-18

Audited by	DAS 14
Date:	9-89 14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order:	119473				
Description: Saddle				Part Number:	D3500-1				
Inspection Dwg: D3500 Rev: C					Page 1 of 1				
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	33	34	35	36	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.377	0.377	0.378	0.377		
F	0.490	0.510		0.500	0.500	0.500	0.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5875	1.5878	1.589	1.587'		
J	0.240	0.260		0.246	0.246	0.246	0.247		
K	0.490	0.510		0.501	0.501	0.501	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.507	6.507	6.507		
P	5.990	6.010		6.005	6.006	6.007	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.1337		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		Ø1.870	Ø1.870	Ø1.870	Ø1.870		
AE	1.810	1.830		⌴0.253	⌴0.253	⌴0.253	⌴0.253		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		0.157	0.157	0.150	0.150		
AH	0.140	0.160		0.155	0.155	0.155	0.155		
AI	0.140	0.160		0.155	0.155	0.155	0.155		
Accept/Reject									

Measured by:	JH
Date:	2014-10-18

Audited by	DAS 14
Date:	9-89 14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD	Work Order:	119473
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	37	38	39	40	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.588		
J	0.240	0.260		0.247	0.247	0.254	0.254		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.507	6.508	6.510		
P	5.990	6.010		6.005	6.005	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1345	1.134	1.1346	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		1.820	1.820	1.820	1.820		
AE	1.810	1.830	0.254	~~0.254~~	~~0.254~~	0.254	0.254		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.154	0.154	0.154	0.154		
AI	0.140	0.160		0.154	0.154	0.153	0.153		
Accept/Reject									

Measured by:	2014-10-18
Date:	JFC

Audited by	DAS 14
Date:	14/10/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

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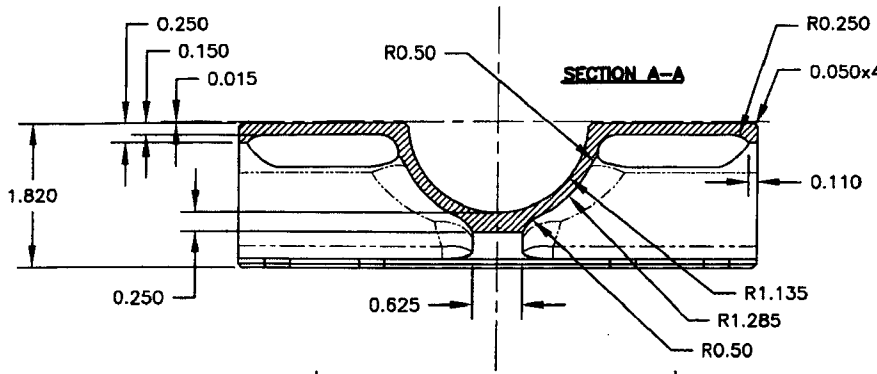
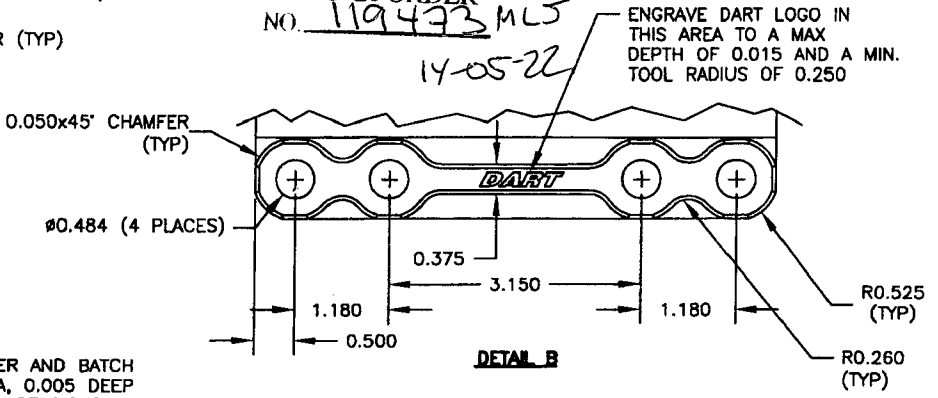
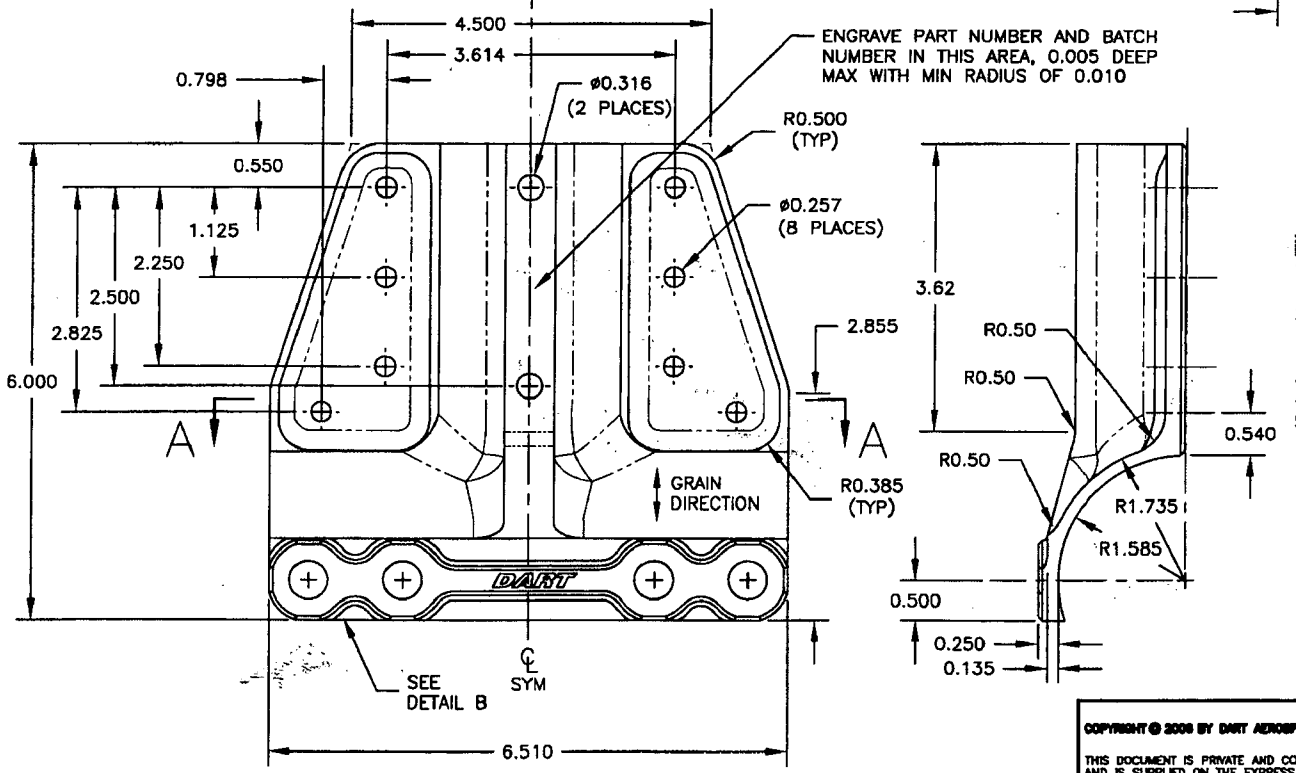
WORK ORDER
NO. 119473 MLJ
14-05-22







D3500–1 SADDLE

1) MATERIAL: 6061–T6/T651 (QQ–A–200/8 OR QQ–A–250/11) (MAKE FROM D6102–013 SADDLE BILLET, 6061)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.08.15

C	06.06.30	MAT'L NOW 6061–T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075–T7351
A	06.04.18	NEW ISSUE

DESIGN: GP	DRAWN BY: PH	DART AEROSPACE LTD. KINGSTON, ONTARIO, CANADA	
CHECKED:	APPROVED:	DRAWING NO. D3500	REV. C
DATE: 06.06.30		TITLE: SADDLE	SCALE: 2:3
			SHEET 1 OF 1